

Work Order ID 83244

83244

Page 1

April-16-12 11:07:12 AM

Item ID: D350-636-014

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 16/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/16* Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

0.00

0.00

S. 26/20

for MLJ 12-6-19

1383244RH

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 30/04/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500" deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill Jig DT8150 & DT8864A for first side only DT8864B for second side (detail B)

7- Clecko DT8864B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***

8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

Handwritten signature and date: 12-04-24

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Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: *M120854*

BE 12/04/12

12-Grind welds flush as per Dwg D2750

CF 12-21-24

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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				6				

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

MG 12-4-25

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

1 0 BE12-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes section BE-BE 0.500" (4 per-side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: M121221

exp. date: 13-1-4

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 11)

A/R Aluminum Rod

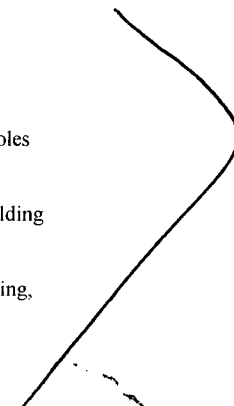
batch: M120854

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

1 ~~0~~ CF 12-4-26



12-04-30

12-4-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 16/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

5/11/07

5/11/07

9/10/07

10/11

1 12/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D380536-014 PAR #: _____ Fault Category: Landing gear/skid tube NCR: Yes No DQA: 2012 Date: 12/04/28
 Resolution: Rework Disposition: Rework QA: N/C Closed: ✓ Date: 12/16/29

NCR: <u>121536</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>12/05/02</u>	<u>#170</u>	Found at inspection that the 15th + 16th hole are missing when tested to the saddle. E.C. Procs / Pulled when welded	<u>CP</u> <u>12.05.02</u> <u>CP/012</u>	Drill out + remove hole + 2 + spacer Repl/22 00743 8 — + 2 Re weld AS per drawing <u>A/R</u>	/	<u>/</u>	<u>CP</u> <u>12.05.02</u> <u>CP/012</u>	<u>S</u> <u>12/05/02</u>
				<u>Grind welds flush + clean</u> <u>OPENED HOLES TO 0.494</u> <u>ACCEPTABLE (P2.05.03)</u>	<u>DP</u> <u>12-2-15</u>	<u>BE</u> <u>12-02-15</u>	<u>CP</u> <u>17.05.02</u> <u>CP/012</u>	<u>S</u> <u>12/15/02</u>

NOTE: Date & initial all entries

Work Order ID 83244

83244

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April-16-12 11:07:12 AM

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 16/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

210

QC3- Inspect Part Finish

0.00

210

QC

Quality Control

Memo

Inspect for foreign object per QSI 024

0.00

IX 12/05/08
1R4 12/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 83244

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April-16-12 11:07:12 AM

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N900040100

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Item Name: Skidtube RH

Stop ***NS2***

Start Date: 16/04/2012 Start Qty: 1.00

1

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Required Date: 30/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00

230

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: ~~110348~~ 110348

3-Assemble tube hardware as per dwg D2750 sikaflex batch: 121221 13/01

4-Inspect For Foreign Objects

5-Spray inside of tube with "LPS-3" batch: N/A

6-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: 121221

EXP DATE: 13/01

7-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 110348

8-Coat all exposed fasteners with "LPS Procyon" batch: 114596

RH 8 (2P) 12/05/08

W/O:		WORK ORDER CHANGES					
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12/06/03	# 230	Found during Assembly that D3488-041/042 Doesn't Align with skid tube R.C. tol on D3488-041/042 + Hammer Drilling Process	GP 12.06.04	Drill out at 45° aft most holes to max tol on skid Drill out at 45° holes to max tol on D3488	 12-6-06	 12/06/06	GP 12.06.04	 12/06/03
			GP 12.06.04	touch up Alodine AS per ASIAOS + Re assembly	BLD-518		GP 12.06.04	 12/06/03

NOTE: Date & initial all entries

Work Order ID 83244

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April-16-12 11:07:12 AM

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

270

Packaging

Packaging

Memo

0.00

0.00

Packaging

Package as per PPP D350-636-014

Rev I
doc 22

12/6/22

280

280

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

12/6/22

MCS 12/06/21

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 83244

83244

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:H02.09.25Rearranged procedure stepsKJ
 IPP Rev:I05.12.08Rearranged procedure stepsEC
 IPP Rev:I06.03.30Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N
 10.06.22 revise seq110 DD verf:EC IPP Rev:O 10.10.01 as
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured

No

110

Each

23.0000

1

1

D2600-3-BENT

B83305

**

① 2012-04-24

Extrusion Bent

Location

Loc Qty

Loc Code

LG

23

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

82347

8

D2739

Manufactured

No

160

Each

6.0000

1

1

D2739

B83449

**

① CF 12-4-26

350 I Beam

Location

Loc Qty

Loc Code

LG

6

72155

1

81508

1

82123

2

82124

2

W/O:		WORK ORDER CHANGES					
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83244

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

281.0000

8

8

D2743

Crossbolt Spacer

BE 12-04-30

Location

Loc Qty

Loc Code

LG

-3

81965

207

LG001

284

67766

4

68251

3

73403

64

74445

1

79517

2

D2744

Manufactured No

160

Each

30.0000

1

1

D2744

Cap

BE 12/04/24

Location

Loc Qty

Loc Code

LG002

30

62715

1

70881

1

78900

28

D3490-1

Manufactured No

160

Each

64.0000

4

4

D3490-1

Cross Bolt Spacer

BE 12-04-30

Location

Loc Qty

Loc Code

LG

55

81976

55

LG001

9

62450

2

74875

4

77042

3

April-16-12 11:07:16 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83244

83244

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,456.000

34

34

AN3C5A

Bolt

**

34 28 12/05/08

Location

Loc Qty

Loc Code

FP001

(21444✓

7

115835

7

ST350

1449

116419

28

117343

13

117764

7

117872

2

119749

23

120423

376

1210168

500

121255

500

AN3C6A

Purchased

No

230

Each

481.0000

4

4

AN3C6A

BOLT

**

4 28 12/05/08

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

480

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693✓

388

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 83244

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

83244

D350-636-014

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

154.0000

4

4

AN6C44A

BOLT

**

4

12/05/08

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

152

120143

25

120465

16

121013

11

121167 ✓

100

AN8C35A

Purchased

No

230

Each

99.0000

1

1

AN8C35A

BOLT

**

1

12/05/08

Location

Loc Qty

Loc Code

FP002

98

115960

1

117834

2

118286 ✓

45

121275

50

ST346

1

114442

0

115188

0

115960

1

AN960C10L

*NAS1149C0332 R

✓ Purchased

No

230

Each

0.0000

38

38

***AN960C10L ***

washer

**

38

12/05/08

121509 ✓

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 83244

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

83244

D350-636-014

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

8.0000

8

8

D2745

Bushing

**

8 (DP) 12/05/08

Location

Loc Qty

Loc Code

FP	81964✓	6
	79518	6
FP001		2
	69529	1
	76142	1

D3488-042

Manufactured No

230

Each

12.0000

1

1

D3488-042

Blade Fitting Assembly, RH

**

1 (DP) 12/05/08

Location

Loc Qty

Loc Code

FP002	82258✓	12
	62003	1
	75068	8
	77015	3

D3492-1

Manufactured No

230

Each

101.0000

8

8

D3492-1

Plug

**

~~8 (DP) 12/05/08~~
8 (DP) 12/05/08

Location

Loc Qty

Loc Code

FP002	81964	14
	69531	8
	74444	2
	76235	4
FP-A		87
	81963	87

83098

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83244

83244

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

21.0000

3

3

D3537-1

Wearpad

**

3

2P

12/05/08

Location

Loc Qty

Loc Code

FG

81362✓

10

79833

10

FP002

11

69817

5

80337

4

81361

2

D3631-1

Manufactured No

230

Each

187.0000

8

8

D3631-1

Washer

**

8

2P

12/05/08

Location

Loc Qty

Loc Code

FG

83588✓

100

81874

100

ST072

87

68062

2

75548

85

D3672-1

Manufactured No

230

Each

1,016.000

8

8

D3672-1

Phenolic Washer

**

Location

Loc Qty

Loc Code

FP001

34

66821

34

ST060

982

72229

4

76277

478

80369

500

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Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83244

83244

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No

230 Each

21.0000 1 1

D3791-1

Wearplate



**

1 (2P) 12/05/08

Location	Loc Qty	Loc Code
FP002 83392 ✓	21	
62239	2	
78897	3	
82168	16	

D3793-1

230 Each

21.0000 1 1

D3793-1

Wearshoe

D 3791-1

83392

Gasket

**

1 (2P) 12/05/08

Location	Loc Qty	Loc Code
FP001 83393 ✓	21	
78901	5	
82171	16	

D3793-3

230 Each

26.0000 1 1

D3793-3

Wearshoe

**

1 (2P) 12/05/08

Location	Loc Qty	Loc Code
FP001	23	
80434	11	
82166 ✓	12	
FP002	3	
78935	3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83244

83244

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

35.0000

1

1

D3794-1

Gasket

**

1 (RP) 12/05/08

Location

Loc Qty

Loc Code

FP

23

82167 ✓

23

FP002

12

75042

4

80435

8

D3794-3

Manufactured No

230

Each

19.0000

1

1

D3794-3

Gasket

**

1 (RP) 12/05/08

Location

Loc Qty

Loc Code

FP002

19

74530

2

80436

17

MS21043-6

Purchased No

230

Each

745.0000

4

4

MS21043-6

NUT

**

4 (RP) 12/05/08

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

725

112314

19

117887

6

118384 ✓

200

120308

500

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Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 83244

83244

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

148.0000

1

1

MS21083C8

NUT

**

1  12/05/08

Location

Loc Qty

Loc Code

304

100

121185 ✓

50

121349

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

42

120731

17

121011

25

NAS1149C0832R

Purchased

No

230

Each

288.0000

1

1

NAS1149C0832R

WASHER

**

1  12/05/08

Location

Loc Qty

Loc Code

ST297

288

114915 ✓

288

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 83244

83244

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

170.0000

4

4

***NAS1515H3I ***

WASHER

**

4 (DP) 12/05/08

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

130

118686

3

119438

1

120360

76

121243 ✓

50

NAS1611-005

Purchased

No

230

Each

204.0000

8

8

NAS1611-005

O-RING

**

8

(DP) 12/05/08

Location

Loc Qty

Loc Code

FP001

204

106099

31

114220 ✓

105

119438

68

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 13

Work Order ID: 83244

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

83244

D350-636-014

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

219.0000

8

8

NAS1611-010

O-RING

**

8 (2P) 12/05/08

Location

Loc Qty

Loc Code

FP

12145 ✓

10

110915

0

120770

10

FP001

209

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

36

121259

50

AN8C21A

Purchased

No

250

Each

119.0000

2

2

AN8C21A

BOLT

**

2 (2P) 12/6/18

Location

Loc Qty

Loc Code

ST343

12145 ✓

119

118758

3

120094

26

121067

20

121167

20

121275

50

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Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 14

Work Order ID: 83244

83244

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2741\

Manufactured No

250

Each

60.0000

1

1

**

[Handwritten signature]

[Handwritten signature]

D2741

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-10

ST466

70

71856

1

76984

19

79516

40

[Handwritten signature]

D3493-1

Manufactured No

250

Each

87.0000

2

2

**

[Handwritten signature]

[Handwritten signature]

D3493-1

Washer

Location

Loc Qty

Loc Code

ST050

87

70697

2

77573

4

78835

40

82023

41

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83244

83244

Parent Item: D350-636-014

D350-636-014

Parent Item Name: Skidtube RH

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

148.0000

2

2

MS21083C8

NUT

**

M121349

SP

Location

Loc Qty

Loc Code

304

100

121185

50

121349

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

42

120731

17

121011

25

NAS1149D0863J

Purchased

No

250

Each

209.0000

2

NAS1149D0863J

WASHER

**

2 1216113

SP

Location

Loc Qty

Loc Code

ST298

209

118078

34

119307

75

120308

100

2

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELO PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83244 MLJ
12/04/16

RELEASED
62-107-22-147

F	INCORPORATE DSI 9413. QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS. CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>PH</u>	DART AEROSPACE USA, INC.	
DRAWN	<u>PH</u>	PORT HADLOCK, WA	
CHECKED	<u>AS</u>	DRAWING NO.	REV. F
MFG. APPR.	<u>AS</u>	D2750	SHEET 1 OF 11
APPROVED	<u>AS</u>	TITLE	SCALE
DE APPR.	<u>AS</u>	350 SKIDTUBE ASSEMBLY	NTS
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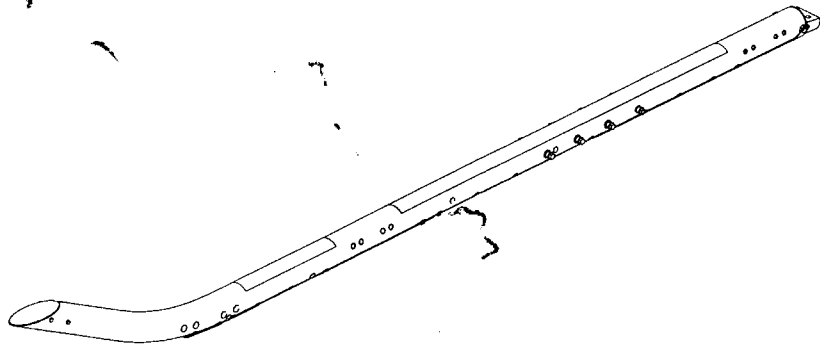
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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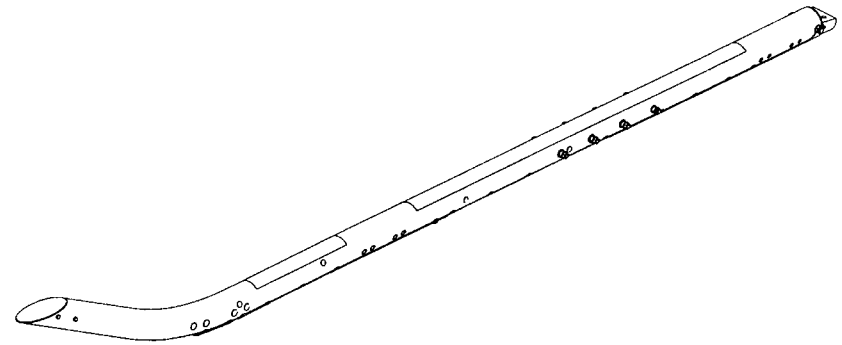
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83244



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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08-09-22-19

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

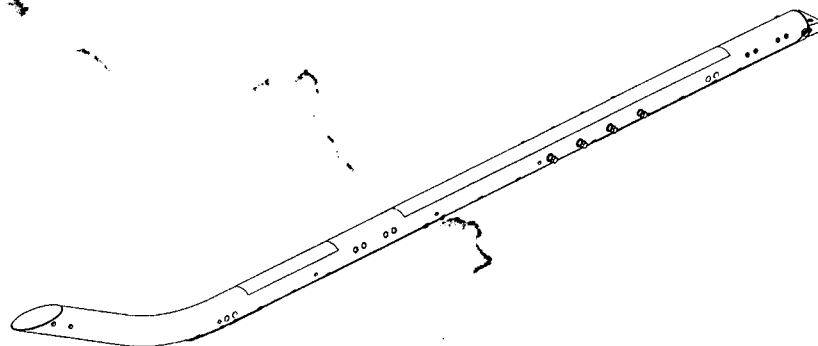
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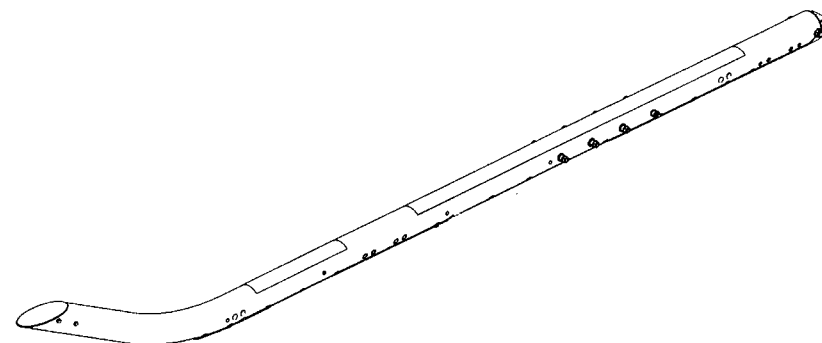
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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83244



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-9-22/11

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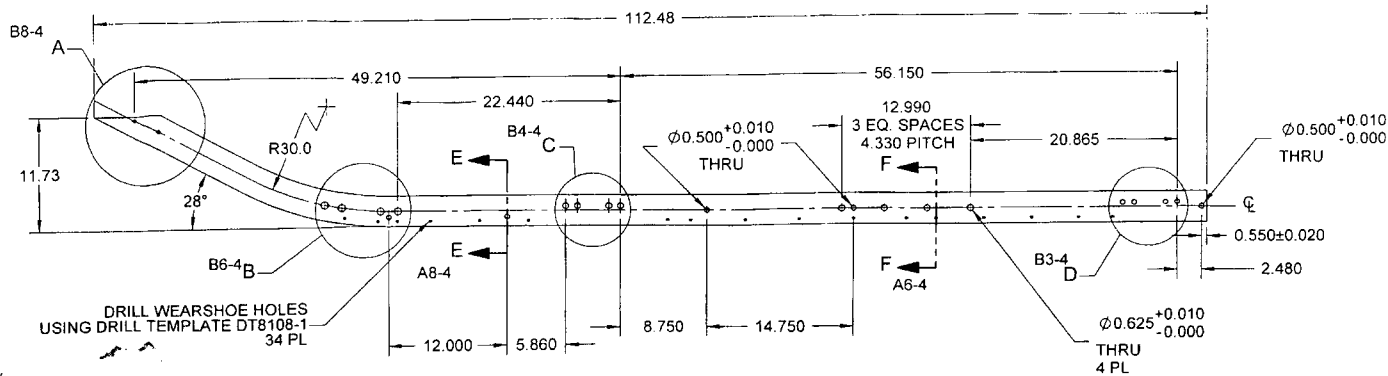
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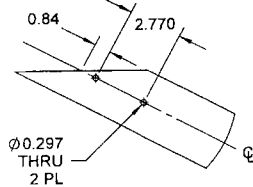
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

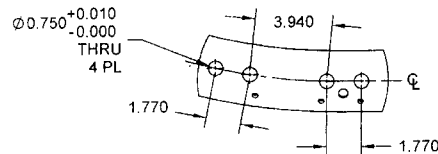
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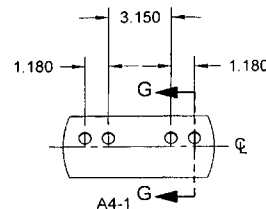
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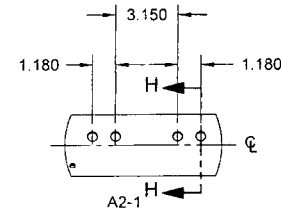
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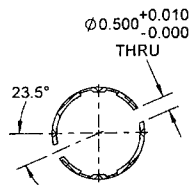
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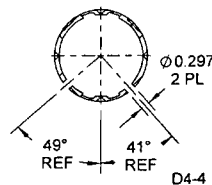
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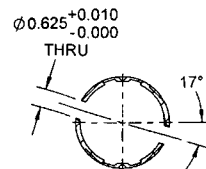
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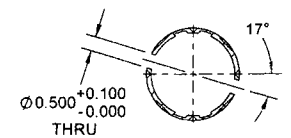
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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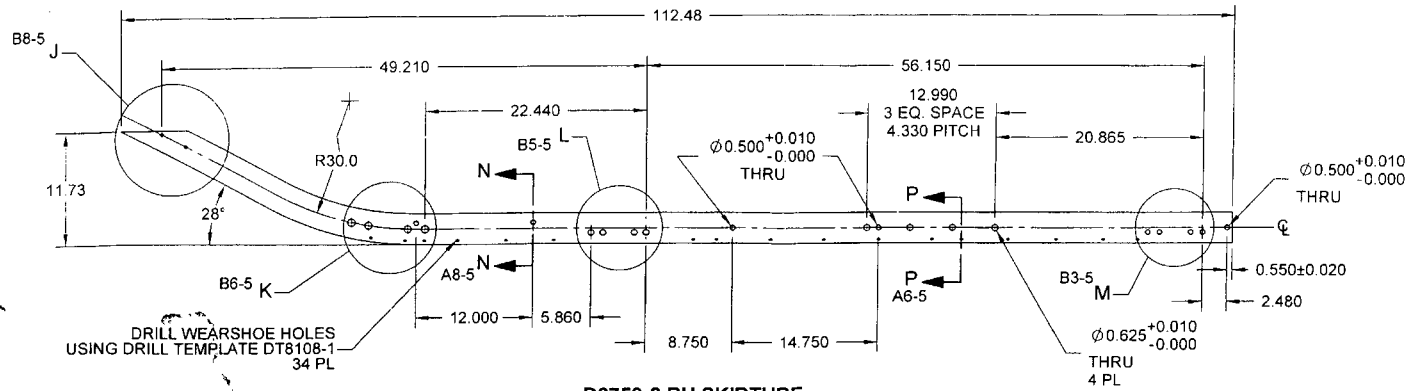
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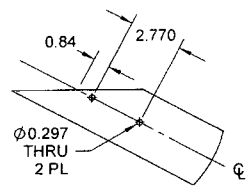
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

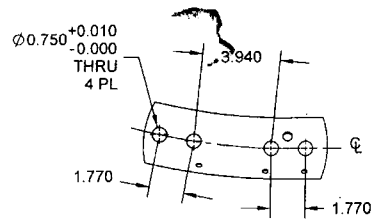
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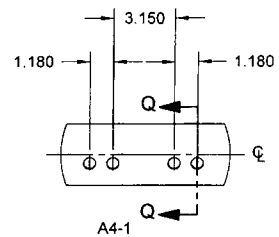
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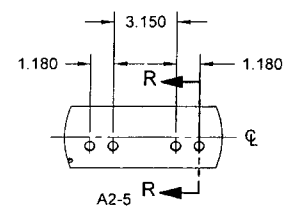
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SCALE 2X



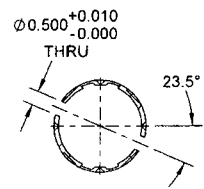
DETAIL K
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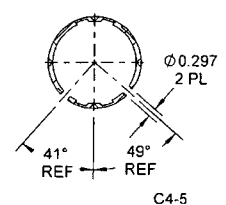
DETAIL L
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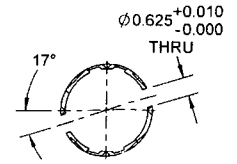
DETAIL M
SCALE 2X



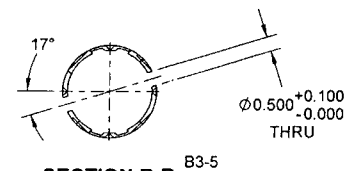
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

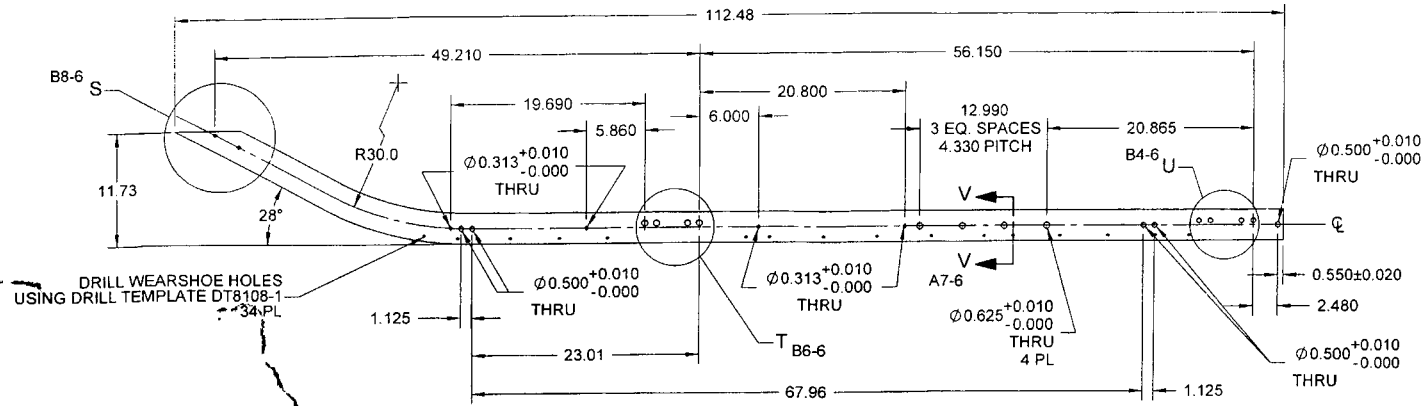
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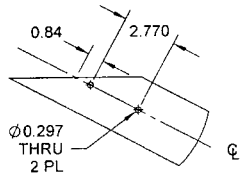
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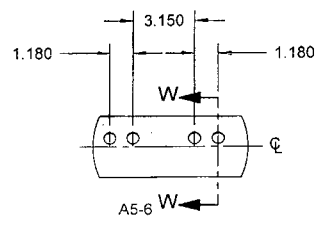
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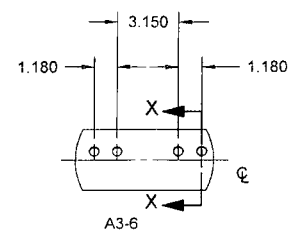
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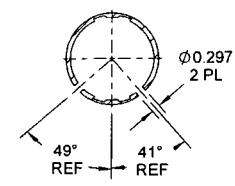
DETAIL S
D8-6
SCALE 2X



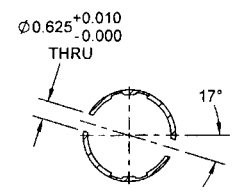
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C5-6
SCALE 2X



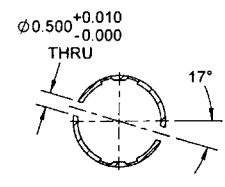
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B6-6
SCALE 3X, 4 PL



SECTION X-X
B4-6
SCALE 3X, 4 PL

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DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
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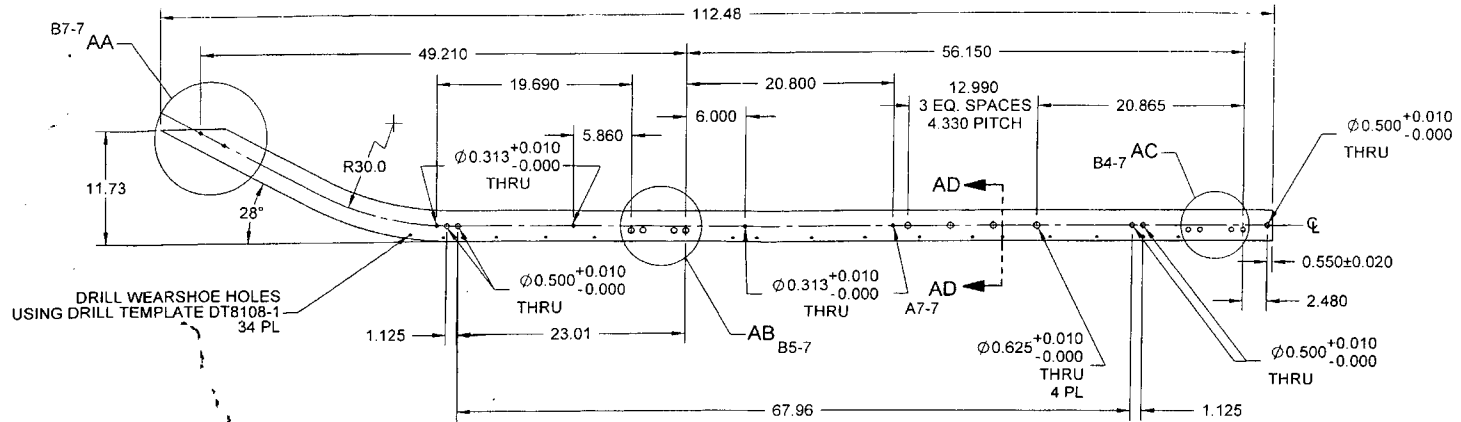
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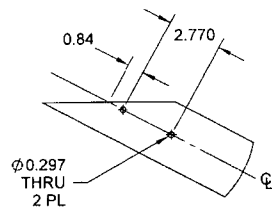
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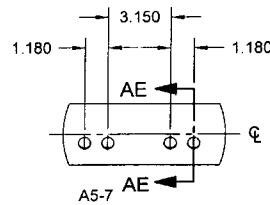
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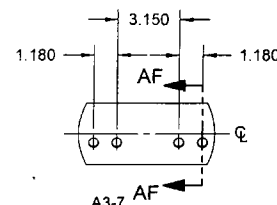
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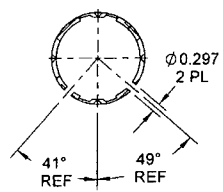
DETAIL AA
D7-7
SCALE 2X



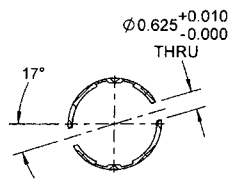
DETAIL AB
C4-7
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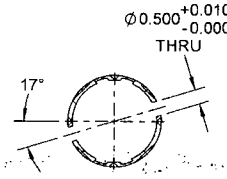
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



SECTION AE-AE
B6-7
SCALE 3X, 4 PL



SECTION AF-AF
B4-7
SCALE 3X, 4 PL

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08-09-22-116

DESIGN		DART AEROSPACE USA, INC.	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

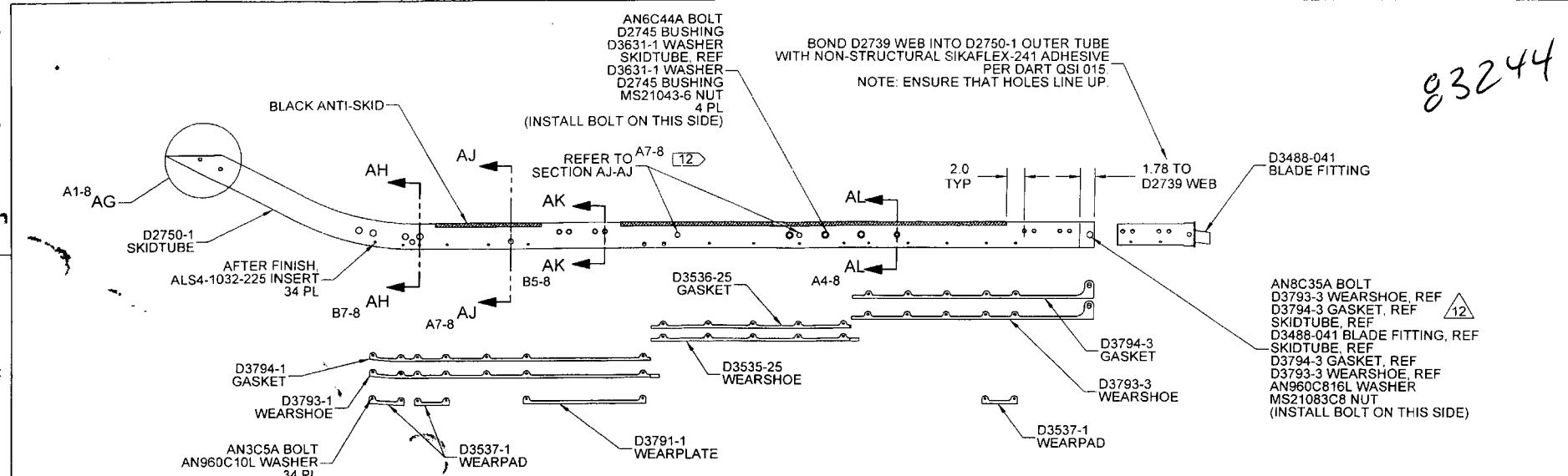
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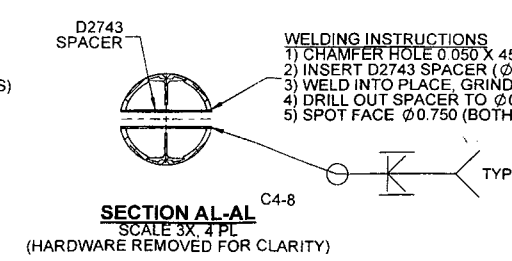
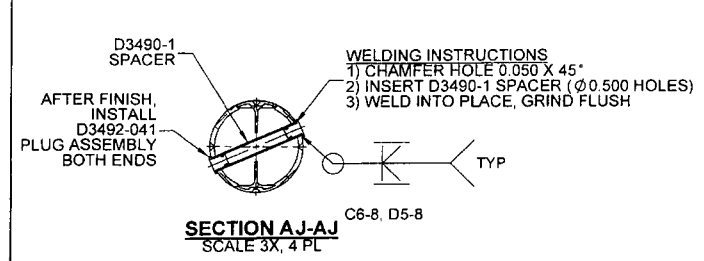
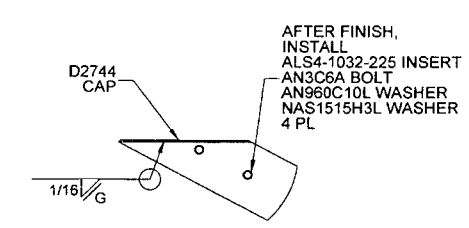
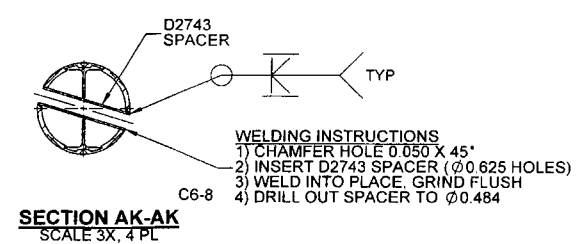
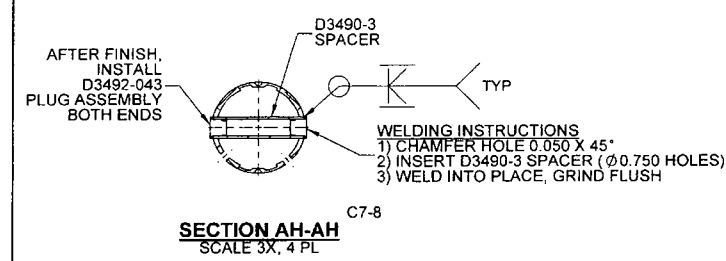
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83244



D2750-041 350 SKIDTUBE ASSEMBLY, LH



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D8-8
SCALE 2X

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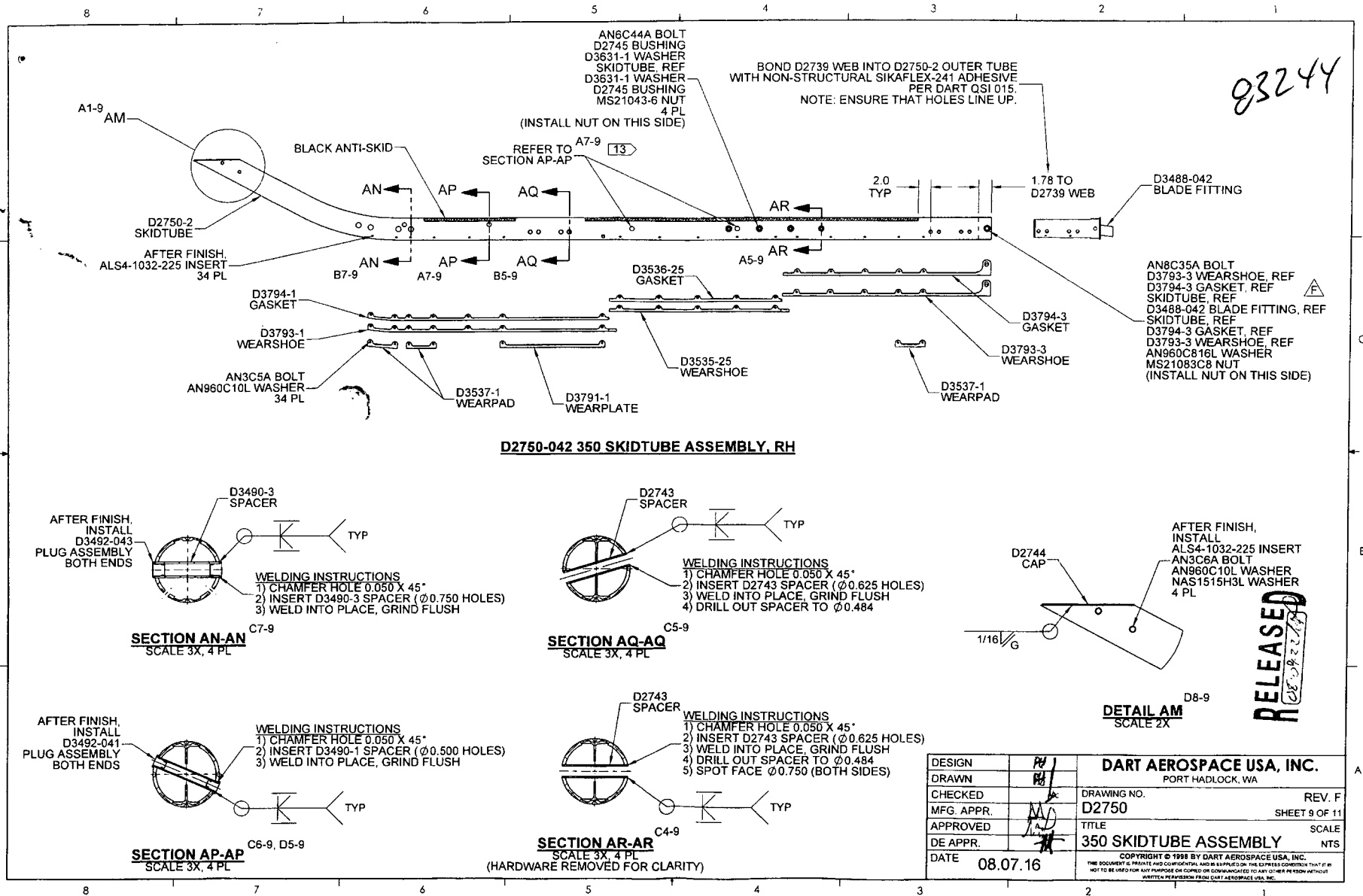
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03244



W/O:		WORK ORDER CHANGES					
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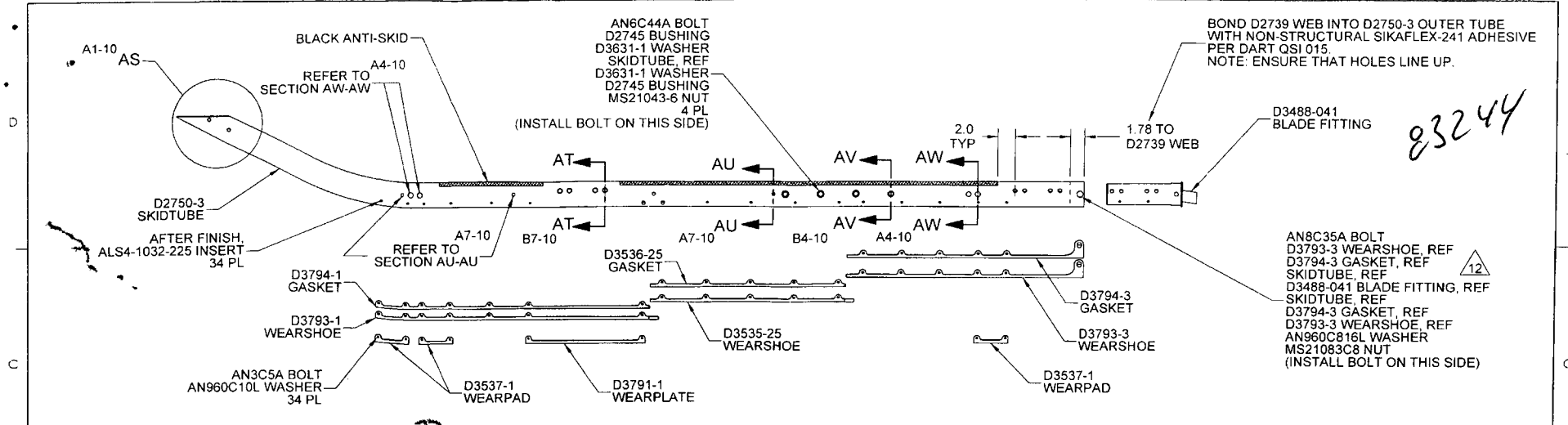
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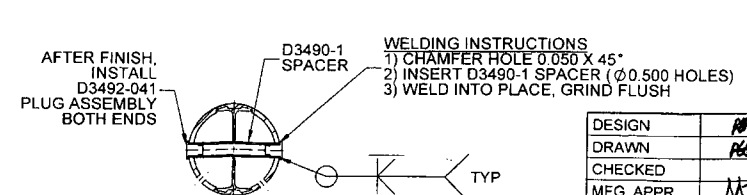
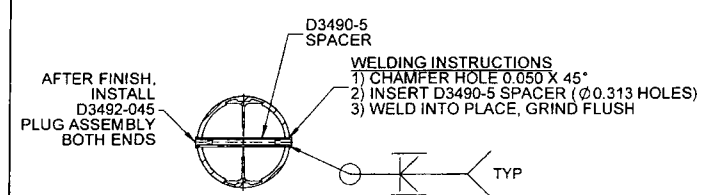
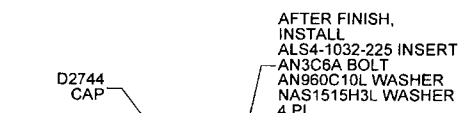
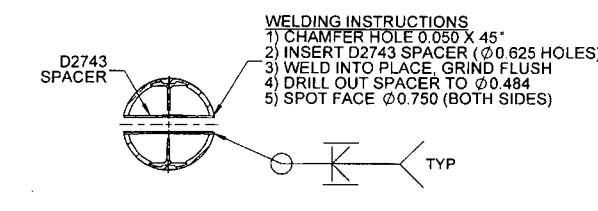
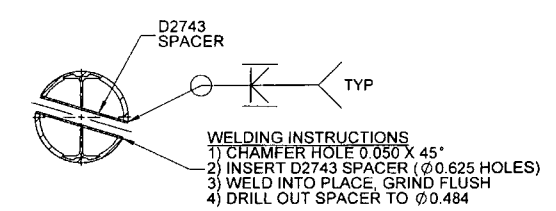
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D2750-043 350 SKIDTUBE ASSEMBLY, LH



DETAIL AS
SCALE 2X

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	
DATE	08.07.16	NTS	

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RELEASED
08-07-16

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

A1-11

BA

BLACK ANTI-SKID

REFER TO
SECTION BE-BE

A4-11

(INSTALL NUT ON THIS SIDE)

AN6C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PLBOND D2739 WEB INTO D2750-4 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.D3488-042
BLADE FITTING

03244

D2750-4
SKIDTUBEAFTER FINISH,
ALS4-1032-225 INSERT
34 PLREFER TO
SECTION BC-BC

A7-11

B7-11

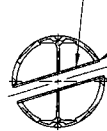
D3794-1
GASKETD3793-1
WEARSHOEAN3C5A BOLT
AN960C10L WASHER
34 PLD3537-1
WEARPADD3791-1
WEARPLATED3536-25
GASKET

A7-11

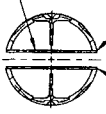
D3535-25
WEARSHOE

B4-11

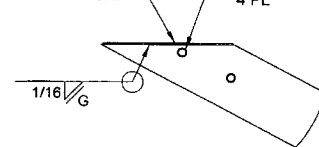
A4-11

D3794-3
GASKETD3793-3
WEARSHOED3537-1
WEARPADAN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON THIS SIDE)**D2750-044 350 SKIDTUBE ASSEMBLY, RH**D2743
SPACERWELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484**SECTION BB-BB**
SCALE 3X, 4 PL

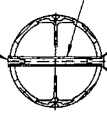
D6-11

D2743
SPACERWELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)**SECTION BD-BD**
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

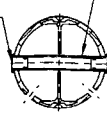
D4-11

D2744
CAP**DETAIL BA**
SCALE 2X

D8-11

AFTER FINISH,
INSTALL
D3492-045
PLUG ASSEMBLY
BOTH ENDSD3490-5
SPACERWELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)
3) WELD INTO PLACE, GRIND FLUSH**SECTION BC-BC**
SCALE 3X, 4 PL

D5-11, C6-11

AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDSD3490-1
SPACERWELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH**SECTION BE-BE**
SCALE 3X, 4 PL

D4-11, D7-11

DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D2750	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 293

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 82796
Part number: 8350-636-014
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Barclay Elliott Date of Test Coupon 12-05-01

Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld